

Delrin 1"

No Folio



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3121-25
Job Sheet 202995



20 pcs only

Part No: D3121-25

Job Qty: 50 pcs

Part Name: Delrin Cap



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/7/19

Job Tracking No:

Due Date: 12/2/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP Rev:A New Issue 06-05-10 JLM IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	50 pcs	12/2/19	12/2/19	0.50	2.50	Hardinge - 1		19/12/14
120	QC 8	50 pcs	12/2/19		0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		19-12-15
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
130	Packaging 3-1 - Stock - B4B	50 pcs	12/2/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		

DAS
65
9-89

				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	M/D
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	50 pcs	12/2/19	0.00 0.00	QC 21 - SA - 21	DAS 21
				QC 21 - SA - 70	
				QC 21 - SA - 53	

DEC 16 2019

Part Op 100 - Hardinge -1-Turn D3121-25 Cap as per Folio FA387
Descriptions: 120 - QC8- Inspect parts - second check
130 - Identify as per dwg & Stock Location: _____
140 - QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MDELINR1.000	Delrin Round Bar 1" Color: Black	1.6000 ft (.032 ea)	100-Hardinge - 1	5208752

12" 5/16

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	MDELINR1.000	2	19	0

R1.250 B.A 11/12/13

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cap	0.315inches ± 0.010	0.325 0.305		
2	Cap	1.000inches ± 0.010	1.010 0.990		
3	Cap	0.838inches ± 0.002	0.840 0.836		
4	Cap	0.063inches ± 0.010	0.073 0.053		
5	Cap	0.010inches ± 0.010	0.020 0.000		
6	Cap	0.230inches ± 0.001	0.231 0.229		
7	Cap	0.865inches ± 0.001	0.866 0.864		

Plex 11/7/19 9:10 AM Dart.lajeunesse.marie



Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only

NCR No.		DEPARTMENT/PROCESS	
Job: _____	DISPOSITION	Skid-tube Machining Large Fab	Cross tube Small Fab Finishing
Part No. _____	Rework Scrap Use-as-is	Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging	Engineering Water Jet Supplier Quality
Date: _____	Sequence #: _____	QTY Affected: _____	
Description Work Order Deviation		Disposition	
		MRB (QS1042)	
		Completed By	
		Lead hand / Supervisor	QC / QA Coordinator
Root Cause		FAULT CATEGORY	
Operator	Pressure/Forced	Contamination	Power Loss/Surge
Manufacturing Process	Bending	Misaligned/off center	Folio/Program
Equip/Tooling	Crushing	BOM/Route	Grain Direction
Handling/Preservation	Cracks	Broken/Damage/Defect	Weld
Material	Crimp/kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled
Product Improvement	Marks/Chatter	Drill Holes	Out of Sequence
Process Improvement	Mislabeled	Fit/Function	Off-set/Set-up
Human Factors	Other/Details:		Positioned Wrong
			Outside Tolerance
			Drawing
			Finish
			Part Lost/Missing
			Misread